

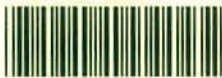
Date: Tuesday, 4/25/2006 10:24:01 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BLOWER MOTOR SUPPORT
Job Number : 26612
Estimate Number : 12308
P.O. Number : NIA Part Number : D34711
This Issue : 4/25/2006 S.O. No. : N/A Drawing Number : D3471 REV.A
Prsht Rev. : NC Project Number : N/A
First Issue : 4/10/2006 Type : SMALL /MED FAB Drawing Revision : A
Previous Run : 26462 Material : NIA
Written By : Due Date : 4/28/2006 Qty: 5 Um: Each
Checked & Approved By :
Comment : est rev A 06.03.02 New issue EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	OUTSIDE SERVICE	OUTSIDE SERVICES
	<p>Comment: Sub-Contracting OUTSIDE SERVICES Issue P/O: _____ Email or Ship DXF file to vendor Cut per Dwg D3471 flat pattern D3471-1F possible supplier: GFI Material release note required</p> <p><i>Make by hand</i> <i>2004 T3 .063</i> <i>Batch #</i> <i>1.08</i></p> <p><i>M16645</i> <i>M16052</i> <i>m19059</i> <i>m16140</i> <i>FF 06-04-25</i></p> <p><i>1</i> <i>2x</i> <i>3x</i> <i>1x</i></p> <p><i>P10</i> <i>5</i></p>	
2.0	D34711F	BASE FLAT PATTERN
	<p>Comment: Qty.: 1.0000 sf(s)/Unit Total : 1.0000 sf(s) SUPPORT FLAT PATTERN</p>	
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	<p>Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached</p>	
4.0	QC6	DIMENSIONAL CHECK
	<p>Comment: DIMENSIONAL CHECK Ensure Material certification comply to Dwg D3471</p> <p><i>06-04-25</i></p>	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	<p>Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr 2-Bend as per dwg D3471</p> <p><i>FF 06-04-25</i> <i>SB 06/04/25</i></p>	

Date	Step	Description	Initial	Action	Sign	Date			
06/04/25	1	1 piece was out of tolerance	JB	Scrap & replace it	JB	06.04.25	JB	JB	JB
	5	1 piece was scrap at the end	JB	Scrap & replace it	JB	06/04/24	JB	JB	JB

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Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 26612

Part Number: D34711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF

06-04-26

5

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-04-26 (5)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

06-04-27 (5)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/28

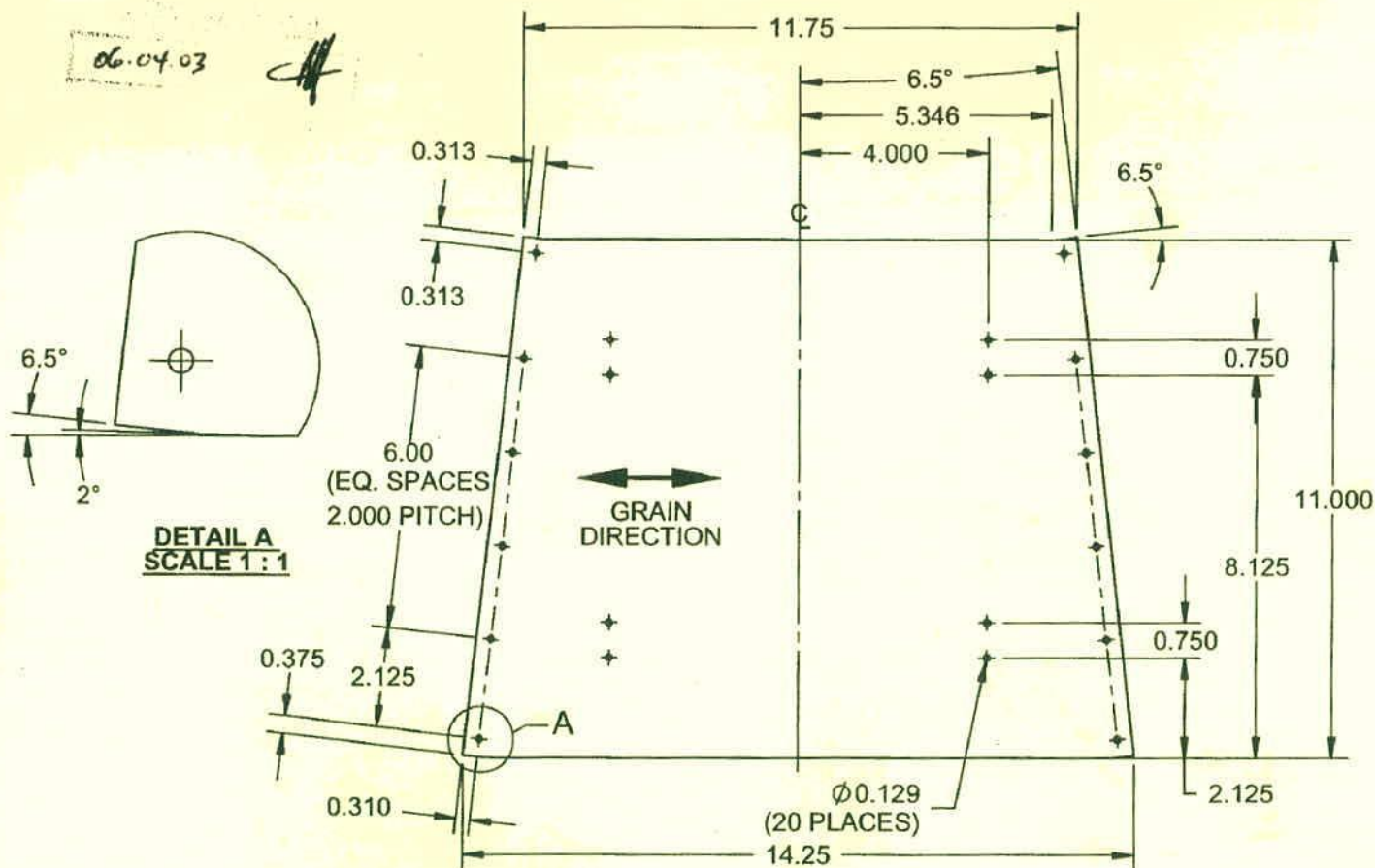
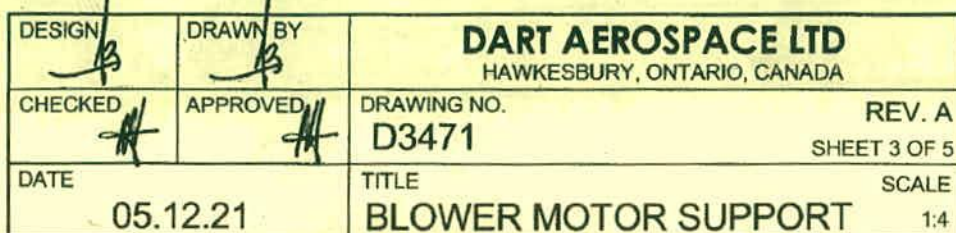
(5)

Job Completion

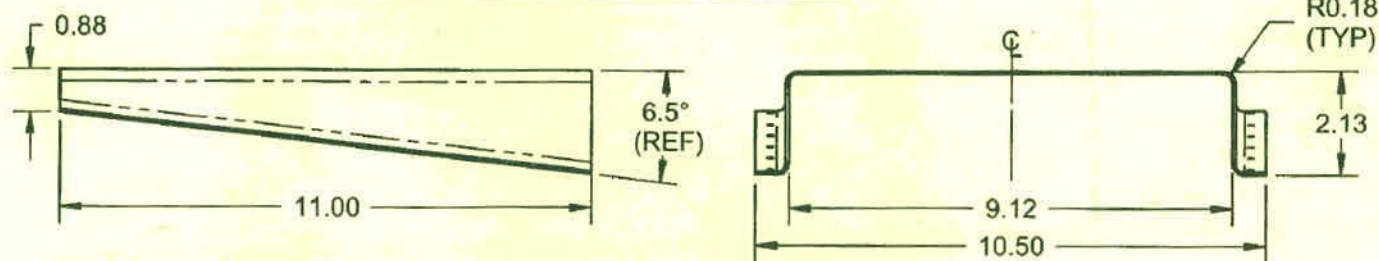


06-04-28

1074
1042
1043
1022



D3471-1F BASE FLAT PATTERN



D3471-1 BASE BENDING DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

REFERENCE ONLY

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